

Date: Monday, 02/10/2006 9:08:39 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: VERTICAL TUBE
Job Number	: 28807		
Estimate Number	: 12312		
P.O. Number	: N/A	Part Number	: D34735
This Issue	: 02/10/2006	S.O. No.	: N/A
Prsht Rev.	: NG	Drawing Number	: D3473 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 27019	Drawing Revision	: B
	Type : SMALL / MED FAB	Material	: N/A
Written By	: _____	Due Date	: 05/10/2006
Checked & Approved By	: _____	Qty:	4
Comment	: Est Rev: A New Issue 06-03-02 JLM Est Rev: B As per Rev B 06-05-24 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S26GA	304/316 0.018 SHEET
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Comment: Qty.: 0.1616 sf(s)/Unit Total: 0.6464 sf(s)

304/316 0.018 SHEET

Batch: M102376

M10 06/10/16

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

Cut as per Dwg D3473

Dwg Rev: B

Prog Rev: B

M10 06/10/16

(4)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

M10 06/10/16

(4)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

206.10.16 (4)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

mf.

06/10/23

(4)

2-Roll & Bead as per Dwg D3473

mf.

06/10/27

(4)

SB

06/10/02

(4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: RD Date: 06/11/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/10/2006 9:08:39 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUBE

Job Number: 28807

Part Number: D34735

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Spot weld as per Dwg D3473

m F. 09/10/27

(4)

6.0

QC5/11

INSPECT WORK/INSPECT SPOT WELD



Comment: INSPECT WORK/INSPECT SPOT WELD

Ad. 11.07 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

GA 57442 P306 11/08 (5)

Took SB 06/11/07 (1)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Doc 11/108 (1)

Job Completion



W 26-11-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

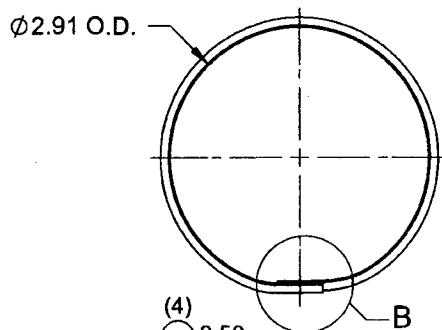
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

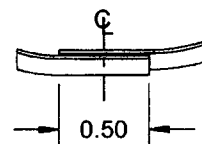
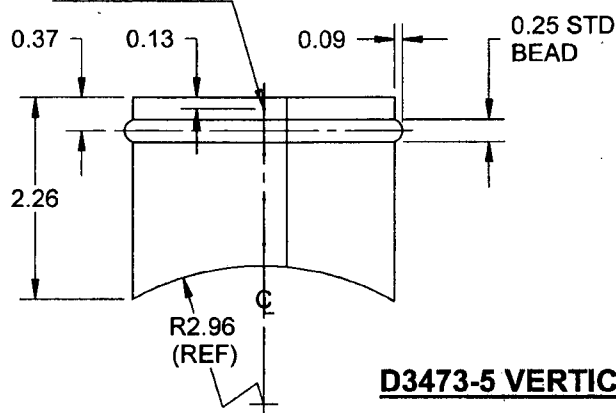
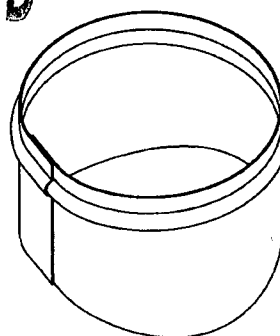
NOTE: Date & initial all entries



DESIGN <i>JB</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>JB</i>	DRAWING NO. D3473	REV. B SHEET 5 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2

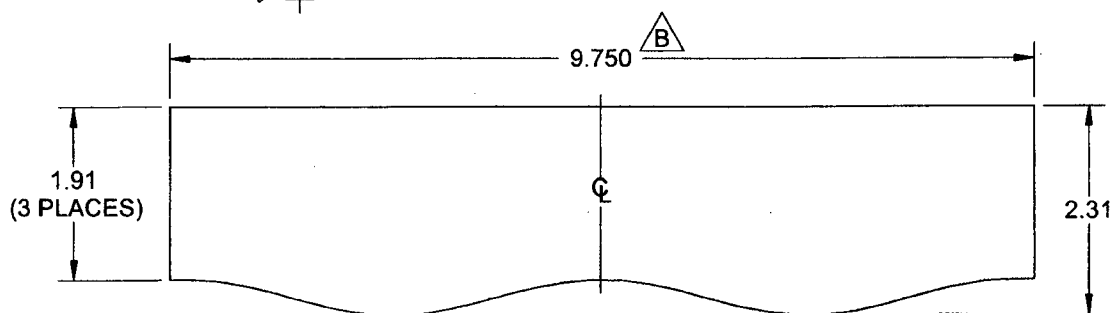


RELEASED
06.05.16



DETAIL B
SCALE 1:1

D3473-5 VERTICAL TUBE



D3473-5F VERTICAL TUBE FLAT PATTERN

REFERENCE ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD
AMS-W-6858A
CLASS 'C'

TEST NO#: 2

EMPLOYEE: Melanie Fauteux

PART NUMBER: D3473-5

JOB NUMBER: B28807

MATERIAL TYPE: 304/316

MATERIAL THICKNESS: .018

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium

TEST RESULTS

	PASS	FAIL
VISUAL:	[/]	[]
PENETRATION:	[/]	[]
PULL STRENGTH:	[/]	[]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 06/10/27

QUALIFIER: Sylvie Soulier